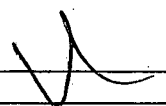
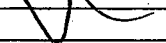


~~CONFIDENTIAL~~ *split*











Date: Tuesday, 15/08/2006 7:19:39 AM  
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 84 BRACKET
Job Number	: 28180		
Estimate Number	: 11035		
P.O. Number	: N/A	Part Number	: D28032
This Issue	: 15/08/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2803 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27302	Drawing Revision	: B
	Type : MACHINED PARTS	Material	: N/A
Written By	: 	Due Date	: 08/09/2006
Checked & Approved By	: 	Qty:	8 Um: Each
Comment	: Est. A 00.11.06 New Issue EC Est Rev:B Blanks now cut on Waterjet 06-06-14 JLM		

Additional Product

Job Number: 

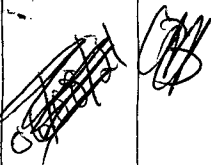
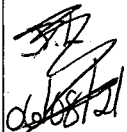
Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X10000	6061-T6 Bar .50" x 10.0"
		
Comment: Qty.: 2.0125 f(s)/Unit Total : 16.1003 f(s) 6061-T6 Bar .50" x 10.0" Material: 6061-T6 bar 10.00" x 0.50" Batch: <i>M101262</i> <i>MA</i> <i>06.08.16</i>		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET 1-Cut as per Template DT8533 Dwg Rev: <u>A</u> Prog Rev: <u>A</u>  2-Deburr if necessary <i>SAD</i> <i>06.08.16</i> <i>8</i>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA102 <i>SD</i> <i>06.08.22</i>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SD</i> <i>06.08.22</i>		
5.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <i>Er</i> <i>06/09/02</i>		
<i>56</i> <i>re Machine- per Rev. B</i> <i>Er</i> <i>06/09/02</i>		

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
								

**NOTE:** Date & initial all entries

Date: Tuesday, 15/08/2006 7:19:39 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 28180

Part Number: D28032

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Tumble & Deburr

SA 06.08.22

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

06.09.05 (8)

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

GA 06 09 14 (8)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

GA 06 09 18 (4)

10.0	DC	DOCUMENT CONTROL
------	----	------------------



Comment: DOCUMENT CONTROL  
Inspection Level 21

06/09/18 (4)

Job Completion



06.09.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

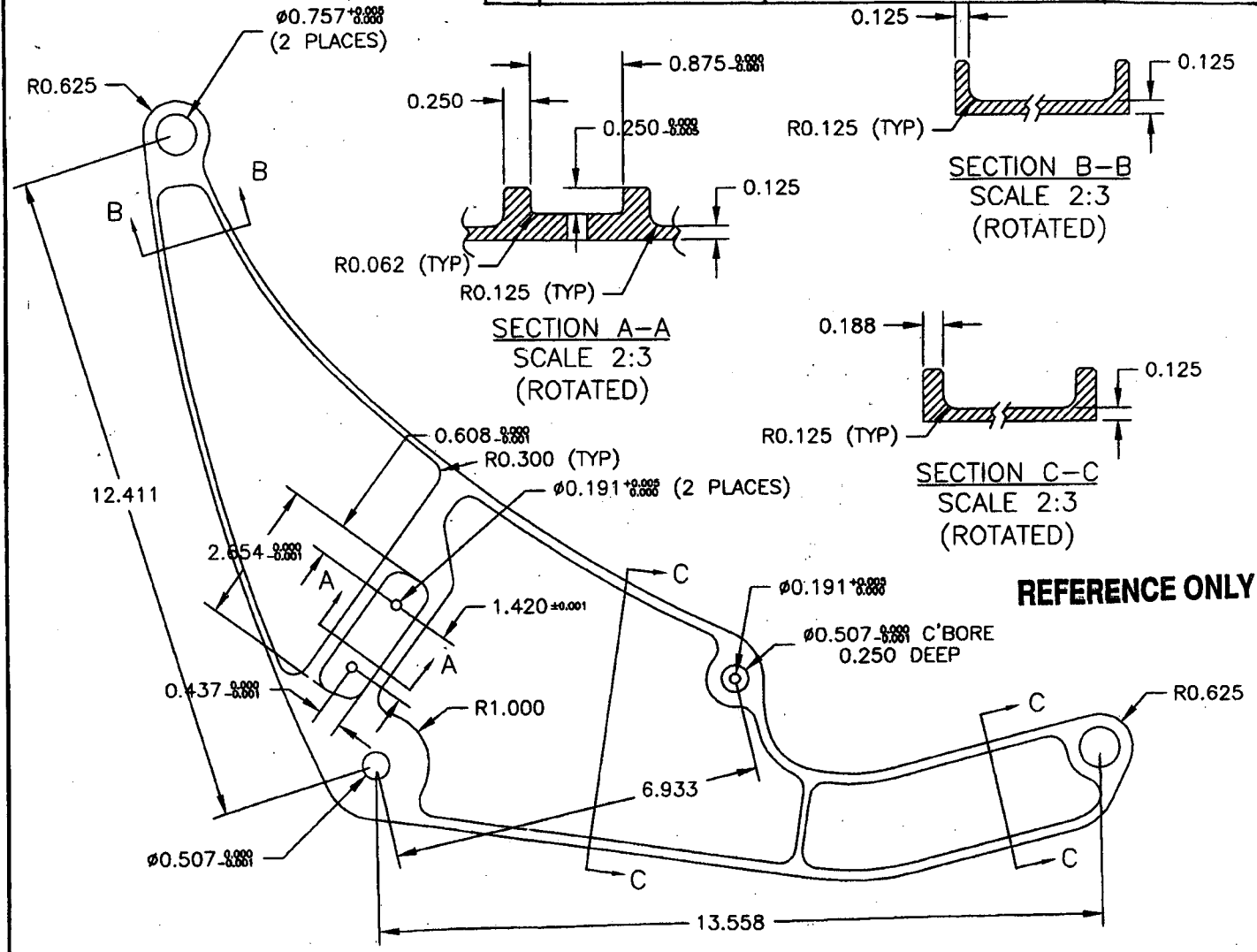
SUPERCEDED BY

05.02.18

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2803	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2803-043/-044 <i>CP</i>	







D2803-1 (SHOWN)  
D2803-2 (OPPOSITE)

**RELEASED**  
00-11-13

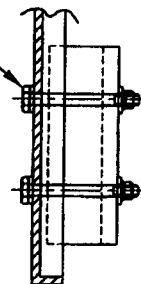
MACHINE PER DRAWING FILE "D2803-A1.DWG"  
 MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK  
 DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. A SHEET 2 OF 2
DATE 00.11.07	TITLE STA 84 BRACKET		SCALE 1:3

**RELEASED**  
00.11.13


AN3-16A BOLT (1)  
AN960JD10 WASHER (2)  
MS21042L3 NUT (1)  
(2 PLACES)



USE D2803-1 FOR D2803-041 + -043  
USE D2803-2 FOR D2803-042 + -044  
**SECTION D-D**  
SCALE 1:3  
(ROTATED)

USE D2805-3 FOR D2803-043  
USE D2805-4 FOR D2803-044  
USE D2805-1 FOR D2803-041  
USE D2805-2 FOR D2803-042  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE  
PRIOR TO POWDER COAT

D2803-041 ASSEMBLY (SHOWN) → D2803-043 SIMILAR  
D2803-042 ASSEMBLY (OPPOSITE) → D2803-044 SIMILAR 

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY  
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX  
(4.3.5.8) PER DART QSI 005 4.3

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Work Order: 28180  
Part Number: D2803-2  
Page 1 of 1

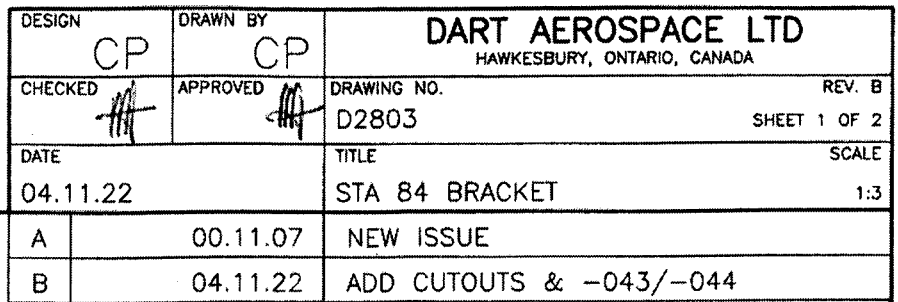
S7A 84 Bracket (odd style)

# FIRST ARTICLE INSPECTION CHECKLIST

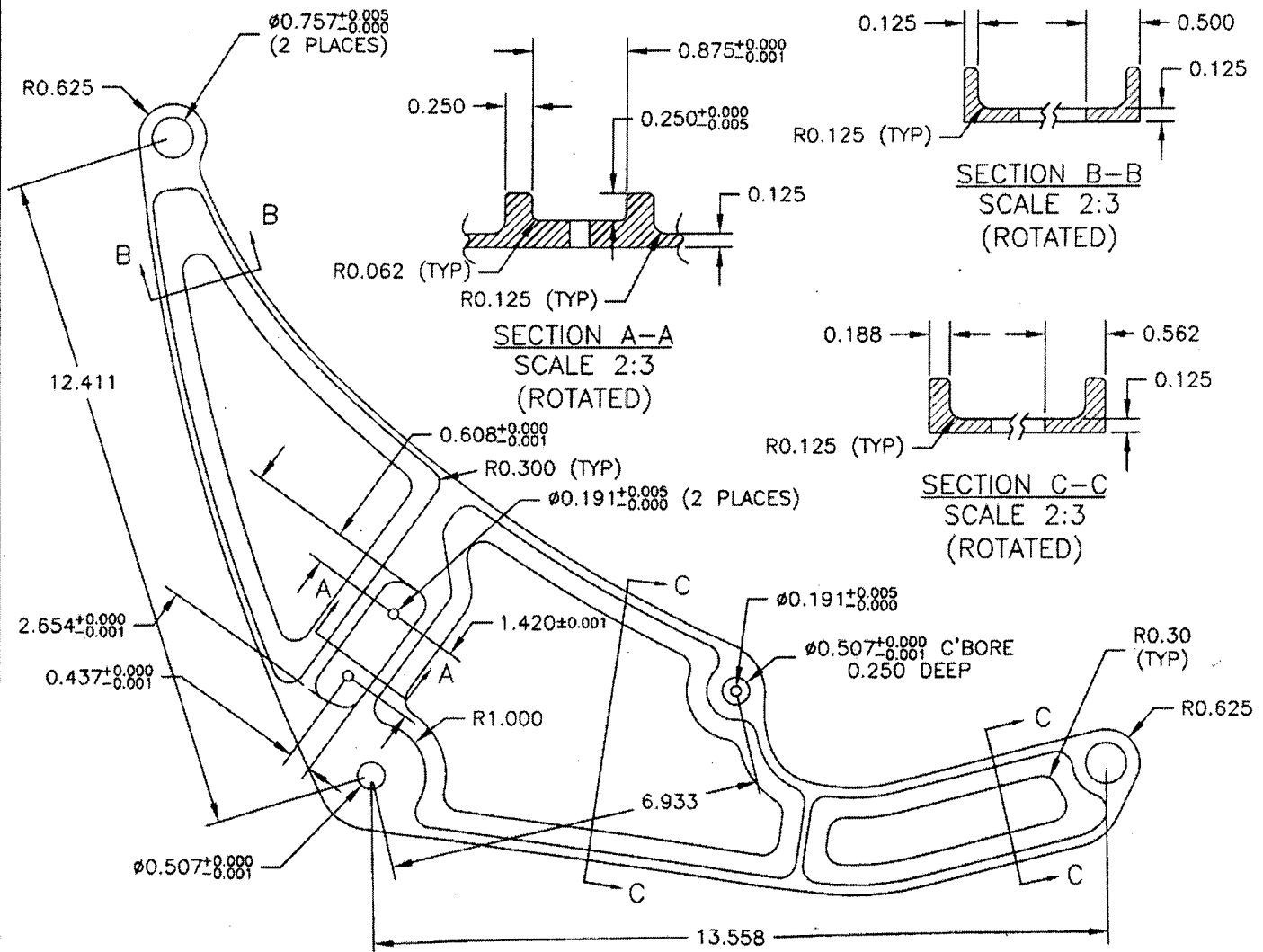
First Article ☒ Prototype

	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.757	+0.006 -0.001	Ø.757	/			
Ø.507	+0.000 -0.001	Ø.507	/			
R.625		R.626	/			
Ø.191		Ø.193	/			
1.420	+0.001	1.419	/			
.250	+0.010	.248	/			
.875	+0.000 -0.001	.874	/			
.250	+0.000 -0.005	.245	/			
.125	+0.010	.130	/			
<del>R.063</del>		R.063	/			
.125		.127	/			
R.125		R.125	/			
.188		.190	/			
.125		.130	/			
13.558	+0.010	1.559	/			
12.411	+0.010	12.410	/			
6.933	+0.010	6.931	/			
0.562	+0.010	0.568	/			
0.500	+0.010	0.501	/			

Inspected by: J.F. / gnd	Prototype Approval: W/A
Date: 06/09/02	Date: 06/08/02
Revised by: KJRF	Approved: KJRF



05.03 11



**REFERENCE ONLY**



- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

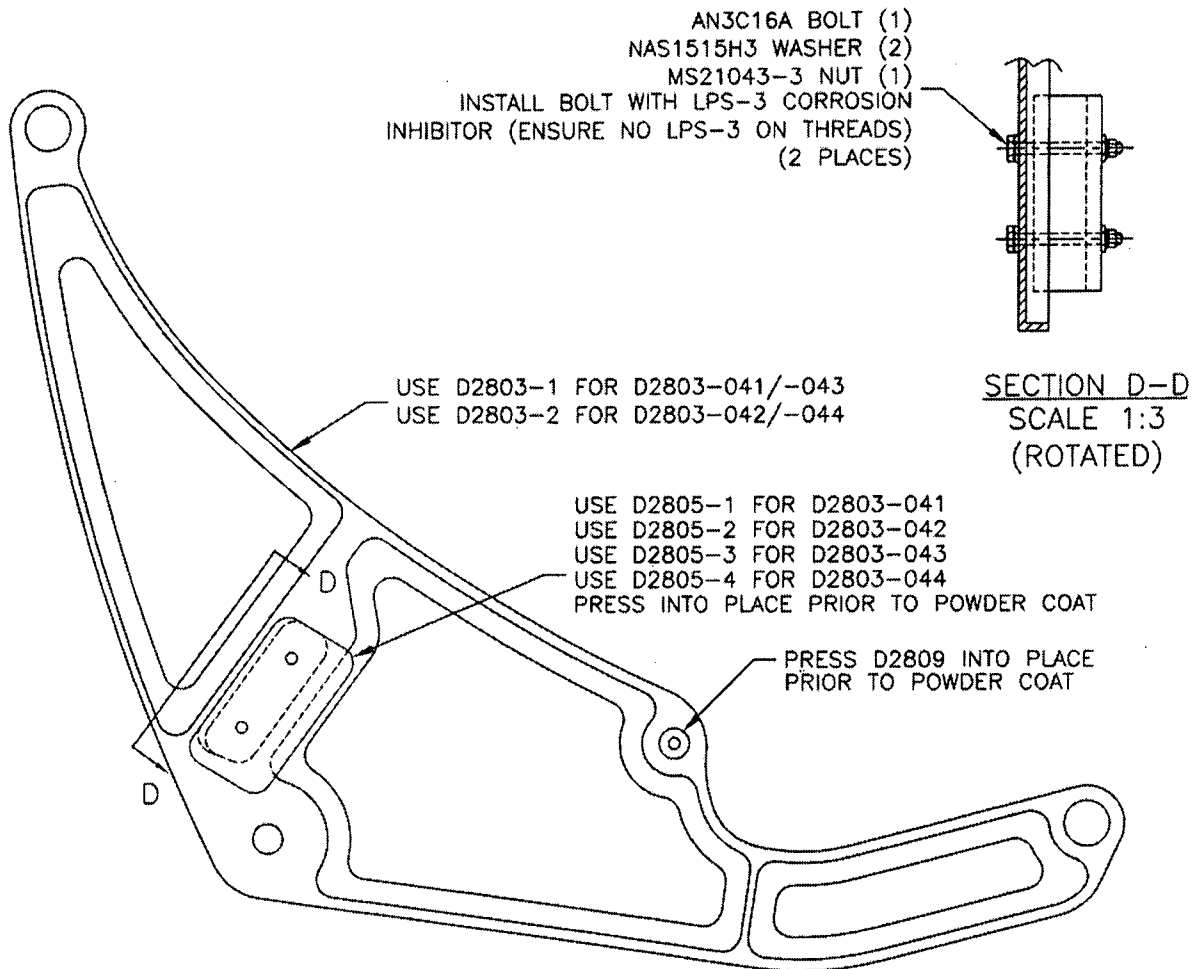
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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3



RELEASED

05-03-11 

REFERENCE ONLY

D2803-041/-043 BRACKET ASS'Y (SHOWN).  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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